

GENERAL INFORMATION

Unit: mm (in)

CRANKCASE/TRANSMISSION			STANDARD	SERVICE LIMIT
ITEM				
Shift fork	I.D.		12.000 – 12.021 (0.4724 – 0.4733)	12.03 (0.474)
	Claw thickness		5.93 – 6.00 (0.233 – 0.236)	5.9 (0.23)
Shift fork shaft	O.D.		11.957 – 11.968 (0.4707 – 0.4712)	11.95 (0.470)
Transmission	Gear I.D.	M5, M6	31.000 – 31.016 (1.2205 – 1.2211)	31.04 (1.222)
		C2, C3, C4	33.000 – 33.025 (1.2992 – 1.3002)	33.05 (1.301)
	Gear bushing O.D.	M5, M6	30.955 – 30.980 (1.2187 – 1.2197)	30.93 (1.218)
		C2, C3, C4	32.955 – 32.980 (1.2974 – 1.2984)	32.93 (1.296)
	Gear-to-bushing clearance	M5, M6	0.020 – 0.061 (0.0008 – 0.0024)	0.10 (0.004)
		C2, C3, C4	0.020 – 0.070 (0.0008 – 0.0028)	0.11 (0.004)
	Gear bushing I.D.	M5	27.985 – 28.006 (1.1018 – 1.1026)	28.02 (1.103)
		C2	29.985 – 30.006 (1.1805 – 1.1813)	30.02 (1.182)
	Mainshaft O.D.	at M5	27.967 – 27.980 (1.1011 – 1.1016)	27.94 (1.100)
	Countershaft O.D.	at C2	29.950 – 29.975 (1.1791 – 1.1801)	29.92 (1.178)
Bushing-to-shaft clearance	M5	0.005 – 0.039 (0.0002 – 0.0015)	0.06 (0.002)	
	C2	0.010 – 0.056 (0.0004 – 0.0022)	0.06 (0.002)	

Unit: mm (in)

CRANKSHAFT/PISTON/CYLINDER			STANDARD	SERVICE LIMIT
ITEM				
Crankshaft	Connecting rod side clearance		0.10 – 0.30 (0.004 – 0.012)	0.40 (0.016)
	Crankpin bearing oil clearance		0.032 – 0.050 (0.0013 – 0.0020)	0.060 (0.0024)
	Main journal bearing oil clearance		0.020 – 0.038 (0.0008 – 0.0015)	0.048 (0.0019)
	Runout		—	0.10 (0.004)
Piston, piston pin, piston ring	Piston O.D. at 20 (0.8) from bottom		97.965 – 97.985 (3.8569 – 3.8577)	97.900 (3.8543)
	Piston pin hole I.D.		24.002 – 24.008 (0.9450 – 0.9452)	24.03 (0.946)
	Piston pin O.D.		23.994 – 24.000 (0.9446 – 0.9449)	23.984 (0.9443)
	Piston-to-piston pin clearance		0.002 – 0.014 (0.0001 – 0.0006)	0.046 (0.0018)
	Piston ring end gap	Top	0.25 – 0.40 (0.010 – 0.016)	0.55 (0.022)
		Second	0.40 – 0.55 (0.016 – 0.022)	0.70 (0.028)
		Oil (side rail)	0.20 – 0.70 (0.008 – 0.028)	0.90 (0.035)
Piston ring-to-ring groove clearance	Top	0.065 – 0.100 (0.0026 – 0.0039)	0.115 (0.0045)	
	Second	0.035 – 0.070 (0.0014 – 0.0028)	0.085 (0.0033)	
Cylinder	I.D.		98.005 – 98.025 (3.8585 – 3.8592)	98.100 (3.8622)
	Out of round		—	0.10 (0.004)
	Taper		—	0.10 (0.004)
	Warpage		—	0.05 (0.002)
Cylinder-to-piston clearance			0.020 – 0.060 (0.0008 – 0.0024)	0.200 (0.0079)
Connecting rod small end I.D.			24.020 – 24.041 (0.9457 – 0.9465)	24.051 (0.9469)
Connecting rod-to-piston pin clearance			0.020 – 0.047 (0.0008 – 0.0019)	0.067 (0.0026)